

# Work Order ID 86825

**\*86825\***

Page 1

July-06-12 3:00:54 PM

Item ID: D3417-9 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Washer  
 Start Date: 7/06/12 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 7/06/12 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: P Date: 7-07-12 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3417	F								
100	Hardinge CNC LATHE SMALL	0.00							
<b>*100*</b>									
Doosan	<b>Memo</b>	0.00							
Doosan Lathe	1-Turn as per Folio FA954								
	Folio Rev: _____								
	Dwg D3417 Rev: _____								
	2-Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									

DAS  
13  
9-89 127131

DAS  
13  
9-89 127131

2e  $\phi$

2e  $\phi$

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	SL	12-07-31					
130 <b>*130*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>44</u>  Memo	0.00 0.00							12/7/31 
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							12/8/11 

MCJ 12 07 131

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**NOTE:** Date & initial all entries

# Picklist Print

July-06-12 3:00:53 PM

Page 1

Work Order ID: 86825

Parent Item: D3417-9

Parent Item Name: Washer

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 20.00

Required Qty: 20.00

Comments: lpp Rev:A New Issue 10-08-03 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRI1.2500 DELRI ROUND BAR 1.25"		Purchased	No				f	7.4200		0.623158			

Location

Loc Qty

Loc Code

MAT055

7.42

119133

0.92

121971

6.5

624 DAS 13 9-89

1217/31

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**NOTE:** Date & initial all entries



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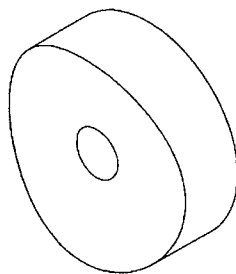
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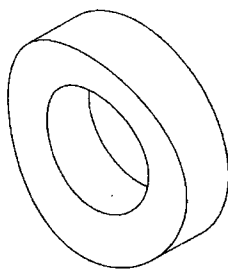
**NOTE:** Date & initial all entries



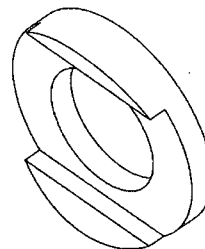
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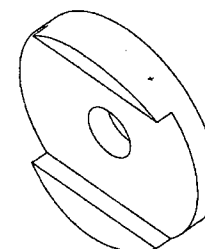
**D3417-1 WASHER**



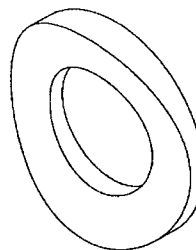
**D3417-3 WASHER**



**D3417-5 WASHER**



**D3417-7 WASHER**



**D3417-9 WASHER**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86825

**RELEASED**  
2010-09-15

**NOTES:**

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD  
REF DART SPEC M-DELRIN-R  
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR  
REF DART SPEC M-DELRIN-B  
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET  
REF DART SPEC M-DELRIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.020 lbs  
D3417-3, 0.010 lbs  
D3417-5, 0.010 lbs  
D3417-7, 0.010 lbs  
D3417-9, 0.004 lbs

F	ADD D3417-9 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.08.30
D	ADD 5 WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	10.07.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

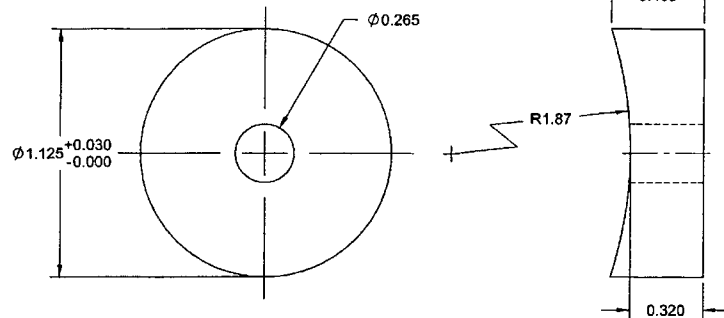
**Dart Aerospace Ltd**

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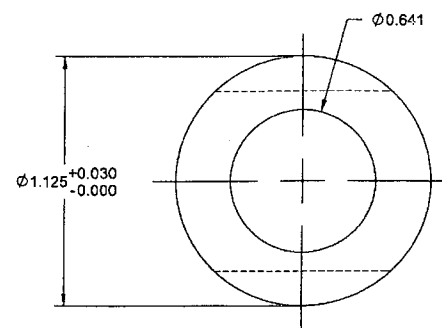
**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

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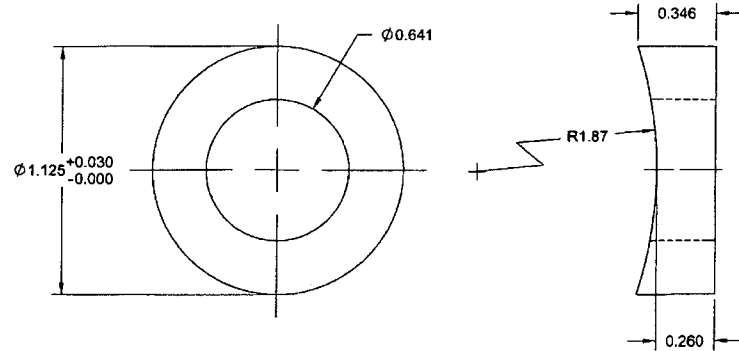
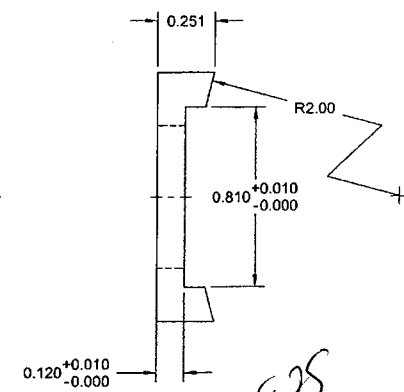
**NOTE:** Date & initial all entries



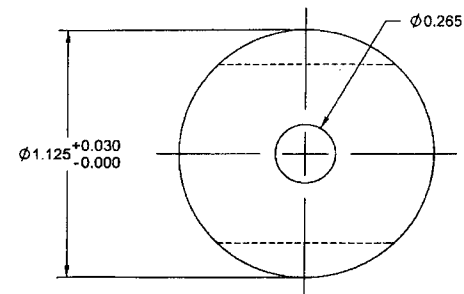
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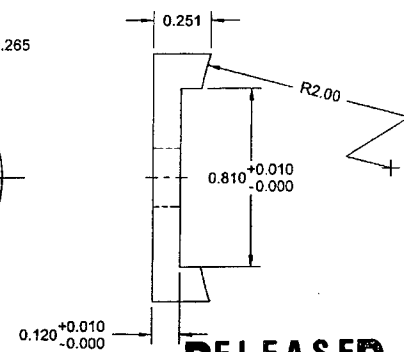
**D3417-5 WASHER**



**D3417-3 WASHER**



**D3417-7 WASHER**



**RELEASED**  
2010-09-15

DESIGN	SC	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D3417</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>WASHER</b>	NTS
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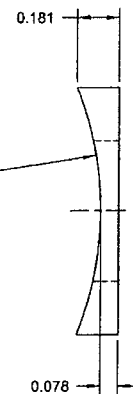
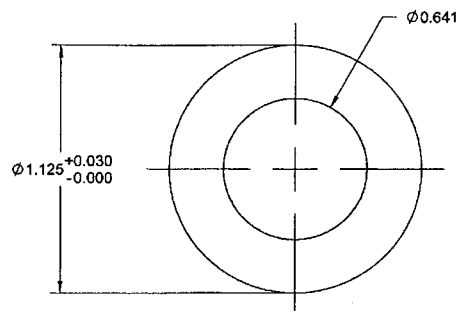
# Dart Aerospace Ltd

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**D3417-9 WASHER**

*SL825*

**RELEASED**  
2010-09-15  
*ND*

DESIGN	SC	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3417</b>	REV. F
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>WASHER</b>	NTS
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